

Work Order ID 55319

January 13, 2010 10:21:27 AM

Page 1

Item ID: D2151

Accept

Setup Start

Revision ID:

Stop

Item Name: Packer Doubler, Hinge

Start Date: 1/13/10 Start Qty: 20.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2151

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2151 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

AB 10-1-21

2074 1040

Deburr => m-h 10/6/126

38X

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 10-1-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

208106/126

counter
x38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Deburr

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

0.00

START TIME:

2:45pm

OVEN TEMPERATURE:

2:15pm FINISH TIME:

370 °F

10-01-27

38

9

10-01-27

438

9

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Page 3

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Start Qty: 20.00

Required Date: 1/20/10

Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

Bk 10-01-28.

(38)

9.

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 577

0.00

Packaging

Memo

0.00

Packaging

Pc 10/01/28 (38)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/0398
MF 10-22

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Picklist Print

January 13, 2010 10:21:32 AM

Page 1

Work Order ID: 55319



Parent Item: D2151

Parent Item Name: Packer Doubler, Hinge

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP C00.10.23 Re-format (mpp 2101) IEC
 IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
 IPP Rev:E 06-11-24 As per Rev B JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M2024T3S.040		Purchased	No			110	sf	520.0628	0.7368	1.4		



2024-T3 .040 sheet



B 10-1-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

520.0627789

110305

192

110337

6.4

111786

32.0665789

112291

50.1264

112331

82.8641

113162

156.6057

38

$$112291 \times 19 = .7$$

$$113162 \times 19 = .7$$

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DART AEROSPACE LTD		Work Order:	55319
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.101	*			
Ø0.171	+0.005/-0.000	.174	*			
0.231	+/-0.010	.230	*			
1.217	+/-0.010	1.215	*			
2.194	+/-0.010	2.197	*			
2.300	+/-0.010	2.299	*			
1.560	+/-0.010	1.560	*			
0.250	+/-0.010	.256	*			
1.328	+/-0.010	1.327	*			
0.342	+/-0.010	.341	*			
0.740	+/-0.010	.737	*			
2.050	+/-0.010	2.047	*			
0.040	+/-0.010	.041	*			

Measured by:	JB	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-21	Date:	10/01/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	JB

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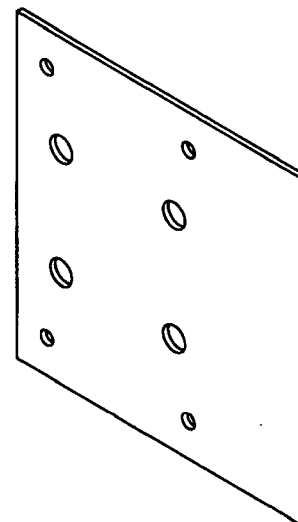
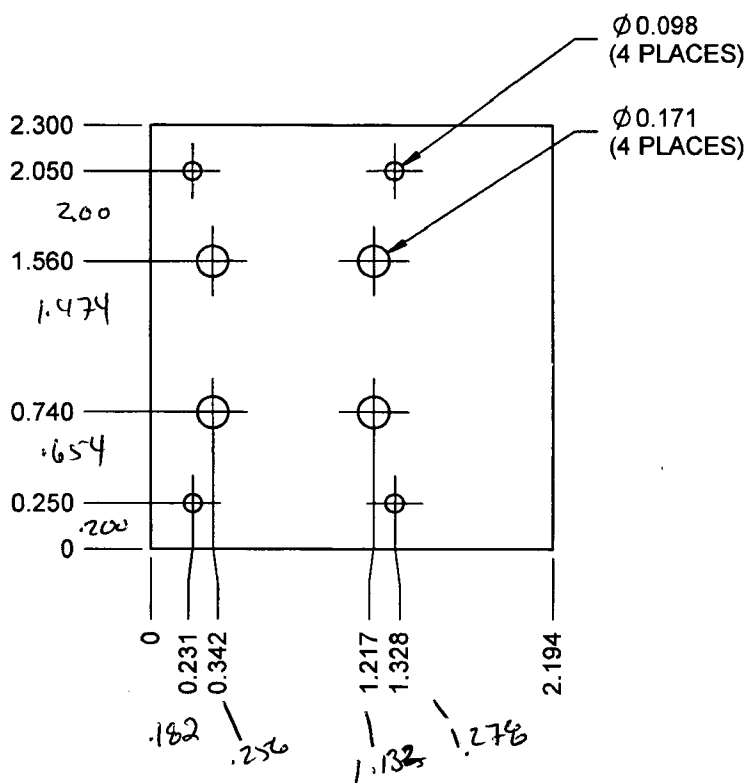
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13	TITLE PACKER		SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED06.11.20 **[Signature]**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **55319**

**D2151 PACKER**

085

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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